

~~32~~ (new). The method of claim ~~31~~, wherein the weight of the wet-strengthened paper is from 10 to 15 g/m².

~~33~~ (new). The method of claim ~~31~~, wherein the weight of the wet-strengthened paper is from 10 to 13 g/m².

~~34~~ (new). The method of claim ~~13~~, wherein said step of impregnating with viscose comprises:

- a) feeding the viscose under pressure through the lips of a die directly onto the outer surface of said tubing and through the wet-strengthened paper;
- b) supporting the paper on its underside during transit across the lips by a metal ring or cylinder, wherein the distance between the faces of the lips and the surface of the supporting ring is 0.5 to 0.7 mm and allows the paper to pass unimpeded; and
- c) impregnating the paper by continuing the passage of the tube between die and supporting ring or cylinder for a predetermined distance within fixed cap dimensions, thereby continuously impregnating the paper.

~~35~~ (new). The method of claim ~~34~~ wherein the distance between the faces of the lips and a surface of the supporting ring is 0.55 to 0.66 mm.

~~36~~ (new). The method of claim ~~34~~, wherein the length of the supporting ring is from 10 to 25 mm, which extends to a distance horizontal to a lower end of a lower lip of the die.

~~37~~ (new). The method of claim ~~34~~, wherein the die has an annular opening in its lower part thereby permitting the viscose to be fed in the lower part of the die.

~~38~~ (new). The method of claim ~~34~~, wherein the paper lead-in distance between the paper supporting ring or cylinder and an upper end of an upper lip of the viscose die, to the point of the viscose issue at a lower end of an upper lip is between 5 and 10 mm, while the paper lead-out distance, between the point of viscose issue and a lower end of a lower lip is between 2 and 10 mm.

A marked-up copy of the amended claim is attached to this amendment. Inserted material is indicated by underlining and deleted material is indicated by square brackets.

Clean Copy of Amended Claim 13

13.(three times amended). A method for manufacturing a fibrous cellulose sausage casing having elasticity in the range 13 to 20% of the starting size, elasticity being defined as the capacity of the casing, after soaking in water at 40°C for 10 minutes, to expand from an uninflated condition to one of inflation by 30 kPa air pressure, which method comprises:

- a) forming a wet-strengthened manila based paper material, which paper is wet-strengthened by at least one strengthener selected from the group consisting of i) synthetic resin(s) of polyamide epihalohydrin type, ii) viscose, and iii) a combination of synthetic resin(s) of polyamide epihalohydrin type and viscose, into the shape of a tubing, the air-dry weight of which wet-strengthened paper is from 10 to 15 g/m²;
- b) impregnating said tubing with viscose by presenting said viscose only to an outer surface of said tubing;
- c) coagulating the viscose into cellulose by passing the impregnated tubing through at least one acid and salt bath; and
- d) plasticizing the treated tubing.